

Date: 6/23/2006 8:55AM
User: Linda Lacelle

PROCESS SHEET

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job No.	: 27678	Part No.	: D3391021
Estimate No.	: 10467	Drawing No.	: D3391 REV E
P.O. No.	: N/A	Drawing Rev.	: E
First Issue	: N/A	Project No.	: N/A
Prsht Rev.	: NC	Material	: N/A
This Issue	: 6/23/2006	Due Date	: 7/30/2006
Prev. Run	: 27677	QTY:	: 1
	Type : MACHINED PARTS		

Written by:

Checked & Approved by:

Comment :

Est. A 05.09.13 New issue KJ/JLM
Est. B 06.02.10 Dwg rev.D ech 773 EC
Est. C 06.05.02 Added inspections EC

Job Number:



Seq. No.	Machine or Operation	Description
1.0	D6013047	SKIDTUBE MAT'L
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) SKIDTUBE MAT'L Pick: Qty Part Number Description Batch 1 D6013-047 Extrusion	1323935 DP06-6-23
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1 Cut extrusion to 46.52 +0.010 -0.020	7/2 06/06/23
3.0	BENDING	BENDING MACHINE
	Comment: Nc bender Bend as per Dwg D3391 Using Bend Prog 3391021	DP06-6-23
4.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	Done 06-06-23 ①
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. E Identify as D3391-1 2-Deburr	7/2 06/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



Seq. No.	Machine or Operation	Description
6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>me 06/07/10</i>
	Comment:	INSPECT PARTS AS THEY COME OFF MACHINE
7.0	QC8	SECOND CHECK <i>J.G 06/08/03</i>
	Comment:	SECOND CHECK
8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment:	LANDING GEAR RESOURCE 1
		1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A")
		2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step
		3-Open tow cap holes to .208" as per Dwg D3391
		4-Open Tow Ring hole to .640" as per Dwg D3391
		5-Drill wearplate holes as per Dwg D3391 Using Dt8217 & DT8878 <i>pmc 06-08-30</i>
		6-Deburr <i>pmc 06-08-30</i>
9.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>06-8-30</i>
	Comment:	INSPECT WORK TO CURRENT STEP
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment:	HAND FINISHING RESOURCE #1
		Acid etch and Alodine as per QSI 005 4.1 <i>a.m 06/10/11</i>
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment:	INSPECT POWDER COAT/CHEMICAL CONVERSION
12.0	POWDER COATING	POWDER COATING <i>FL 06/12/07</i>
		<i>yl 06/12/07 x1</i>
	Comment:	POWDER COATING
		Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 <i>M102391</i>
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment:	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>a.m 06/12/13</i>
14.0	NAS1330C3KB166	INSERT

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



Seq. No.	Machine or Operation	Description
	Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s) Rivnut Pick: Qty Part Number Description Batch 14 NAS1330C3KB166 Insert <u>100732</u>	
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Install Inserts as per Dwg	<i>YC 06/12/13</i>
16.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	<i>FC 06 12 13</i>
17.0	D3401041	Tow Cap Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Tow Cap Assembly Pick: Qty Part Number Description Batch 1 D3401-041 Tow Cap <u>24887</u>	
18.0	AN3C4A	BOLT
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Bolt Pick: Qty Part Number Description Batch 4 AN3C4A Bolt <u>101396</u>	
19.0	NAS1515H3L	WASHER
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Washer Pick: Qty Part Number Description Batch 4 NAS1515H3L Washer <u>102404</u>	
20.0	AN960C10L	washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) washer <u>101340</u>	
21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Install tow Cap as per Dwg D3391 Identify as D3391-021	<i>YC 06/12/13</i>
22.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP Inspect thread of each insert using DT8821	<i>FC 06 12 13</i>

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



Seq. No.	Machine or Operation	Description
23.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>28306A</u> ✓	
24.0	DC	DOCUMENT CONTROL
		<u>07/02/01</u>
	Comment: DOCUMENT CONTROL Inspection Level 21	

Job Completion



U 87-08-01

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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